

Date: Friday, 01/08/2008 3:31:58 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: END FITTING ASS'Y RH		
Job Number	: 40962		Part Number	: D3763044		
Estimate Number	: 13343		Drawing Number	: D3763 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 01/08/2008 S.O. No. :		Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : LARGE FAB ASSY		Due Date	: 21/08/2008 Qty: 4 Um: Each		
Previous Run	: 40686					
Written By	:					
Checked & Approved By	: JUL 08.8.05					
Comment	: Est Rev:A 08-05-20 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
<b>Comment: PACKAGING RESOURCE #1</b> Pick Packing Kit			
2.0	D37631	End Fitting	
<b>Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)</b> End Fitting batch: B 40994 ✓ SP 08.08.13 (SP)			
3.0	D37636	Tube	
<b>Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)</b> Tube batch: B 40730 ✓ SP 08.08.13 (SP)			
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	

**Comment: LARGE FABRICATION RESOURCE 1**

1-make a 0.063" chamfer on D3763-1 fitting before ass'y SP 08.08.13

2-assemble and tack weld as per dwg D3763 using locating pin DT9044 SP 08.08.13

\*\*\*\*\*look at dwg before assembling parts (RH) \*\*\*\*\*

\*\*\*\*\*remove pin before welding\*\*\*\*\*

3-weld as per dwg D3763, QSI004

Alum. rod Batch: M 108037 SP 08.08.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: END FITTING ASS'Y RH

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Part Number: D3763044

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-13

6.0 QC5

INSPECT WORK TO CURRENT STEP



(P/D)

Comment: INSPECT WORK TO CURRENT STEP

PACKAGING RESOURCE #1

7.0 PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: G17

MF 08-08-14

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-14

S.1  
→  
08/08/14

Stockline 145 per day 22

08/08/19

4x

S.2 QC3

M/K 08/08/14

3X

W/O: 40962		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3783-044 PAR #: \_\_\_\_\_ Fault Category: Prod. Eng., Co-cr. NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-14	6.0	No step for Chemical conversion on w/o.	J 10/08/14	Add & estimate in QC3	J 08/08/14	J 08/08/14	J 10/08/14	J 08-08-14

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

